

Ship July 30/15

Work Order ID 135072

135072

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July 28, 2015 10:45:02 AM

Item ID: D350-836-019 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Crosstube Antenna Mount AS350 / AS355
 Start Date: 7/28/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/11/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan SH Date: 20150728 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
GA202-1	A								
100	Document Control	0.00							DAS 02 9-89
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D350-836-019 CH001								JUL 29 2015
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

JUL 28 2015

JUL 29 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Item ID: D350-836-019

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Antenna Mount AS350 / AS355

Stop ***NS2***

Start Date: 7/28/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/11/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							02 9-89
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-836-019								JUL 29 2015
	Location: FC-122 sold								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

54 20150729

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Work Order ID: 135072

135072

Parent Item: D350-836-019

D350-836-019

Parent Item Name: Crosstube Antenna Mount AS350 / AS355

Start Date: 7/28/2015

Required Date: 8/11/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.07.18 AS PER ECN13-561 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4853-1 *D4853-1* Top Bracket (Replaces P/N G13013-1)		Manufactured	No				Each	2.0000		1		DAS 27 9-89	DAS 26 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
	DAS 02 9-89			ST519				2					
				126142				2					
D4854-1 *D4854-1* Lower Bracket (Replaces P/N G13013-2)		Manufactured	No				Each	11.0000				DAS 27 9-89	DAS 26 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
	DAS 02 9-89			st526				11					
				109079				2					
				126502				9					
D4855-1 *D4855-1* Antenna Bracket (Replaces P/N G13013-3)		Manufactured	No				Each	11.0000				DAS 27 9-89	DAS 26 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
	DAS 02 9-89			st526				11					
				126143				5					
				128258				6					

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Work Order ID: 135072

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Parent Item: D350-836-019

D350-836-019

Parent Item Name: Crosstube Antenna Mount AS350 / AS355

Start Date: 7/28/2015

Required Date: 8/11/2015

Start Qty: 1.00

Required Qty: 1.00

D2732-030

Manufactured No

Each

82.0000

2

D2732-030

**

DAS

DAS
26
9-89

Rubber Cushion - 3"

27
9-89DAS
02
9-89LocationLoc QtyLoc Code

FG

2

117118

2

134608

34

ST410

46

133074

46

AN4-16A

Purchased No

Each

166.0000

2

AN4-16A

**

DAS
27
9-89DAS
26
9-89

Bolt

DAS
02
9-89LocationLoc QtyLoc Code

FG

5

121541

5

ST343

161

M132317

161

AN4-11A

Purchased No

Each

78.0000

2

AN4-11A

**

DAS
27
9-89DAS
26
9-89

BOLT

DAS
02
9-89LocationLoc QtyLoc Code

FG

20

120731

20

ST325A

58

M128362

58

NAS1149D0432J

Purchased No

Each

687.0000

8

NAS1149D0432J

**

DAS
27
9-89DAS
26
9-89

WASHER

DAS
02
9-89LocationLoc QtyLoc Code

ST269

687

m131026

687

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Work Order ID: 135072

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Parent Item: D350-836-019

D350-836-019

Parent Item Name: Crosstube Antenna Mount AS350 / AS355

Start Date: 7/28/2015

Required Date: 8/11/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

Each

3,364.000

4

MS21042L4

Locknut

**

DAS

27

9-89

DAS

28

9-89

DAS
02
9-89LocationLoc QtyLoc Code

FP001

2

m124231

2

GA

142

m127813

142

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

3050

m128300

8

m128798

12

m130388

7

m130922

97

m131618

12

m132123

56

m132382

2858

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4

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DAS
02
9-89**5. PARTS LIST**

Qty -019	Qty -111	Part Number	Description
X		D350-836-019	CROSSTUBE ANTENNA MOUNT KIT AS350/355 (P162-350)
	X	D206-836-111	CROSSTUBE ANTENNA MOUNT KIT UNIVERSAL (P162-U)
1	1	D4853-1	TOP BRACKET (REPLACES P/N G13013-1)
	1	D4853-3	TOP BRACKET (REPLACES P/N G13013-5)
	1	D4853-5	TOP BRACKET (REPLACES P/N G13013-7)
	1	D4853-7	TOP BRACKET (REPLACES P/N G13013-9)
1	1	D4854-1	LOWER BRACKET (REPLACES P/N G13013-2)
	1	D4854-3	LOWER BRACKET (REPLACES P/N G13013-6)
	1	D4854-5	LOWER BRACKET (REPLACES P/N G13013-8)
	1	D4854-7	LOWER BRACKET (REPLACES P/N G13013-10)
1	1	D4855-1	ANTENNA BRACKET (REPLACES P/N G13013-3)
2	2	D2732-030	RUBBER CUSHION (REPLACES P/N G13013-4)
2	2	AN4-16A	BOLT
2	2	AN4-11A	BOLT
8	8	NAS1149D0432J	WASHER
4	4	MS21042L4	LOCKNUT

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Approvals: Process Plan: SH Date: 20150728 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
GA202-1	A								
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc. Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D350-836-019 CH001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

SH 2015/7/28

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